Work Order ID 68377

Tuesday, April 12, 2011 1:09:38 PM

~~PRELIMINARY ISSUE~~ Page 1

Item ID: D4323-23 **Accept** **Setup Start** **Stop**

Revision ID: PRELIM

Item Name: Access Panel

Start Date: 4/12/2011 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 4/15/2011 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** MF **Date:** 11-04-12 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4323	~~PA9~~ PA10 / A								
100		0.00							
HandThermo	**Memo**	0.00				x 7			DL 11/04/12
Hand Finishing Thermoforming	I-Cut Sheet to required Blank size								
105		0.00							
HandThermo	Dry Material					x 2			DL 11/04/13
Hand Finishing Thermoforming	**Memo** Dry Sheet as per QSI022 Kydex	0.00							

Temp: 150°F

Time IN: 4:30 pm 11/04/12.

Time OUT: 7:00 am 11/04/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68377

Tuesday, April 12, 2011 1:09:39 PM

Item ID: D4323-23
Revision ID: PRELIM
Item Name: Access Panel
Start Date: 4/12/2011 **Start Qty:** 2.00
Required Date: 4/15/2011 **Req'd Qty:** 2.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00				x2			DL 11/04/13
Thermoform	**Memo**	0.00							
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA107 using tool DT9733 Dwg Rev: PA9 Folio Rev: A								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				x2			DL 11/04/13
QC	**Memo**	0.00							
Quality Control	Visuallly inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00				x2			JB 11/04/13
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68377

Tuesday, April 12, 2011 1:09:39 PM

Item ID: D4323-23
Revision ID: PRELIM
Item Name: Access Panel
Start Date: 4/12/2011 **Start Qty:** 2.00
Required Date: 4/15/2011 **Req'd Qty:** 2.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
HandThermo	**Memo**	0.00				x2			DL 11/04/13
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				2			11/4/14 Per PA10 only
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00				2			11/4/14 Per PA10 only
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 68377

Tuesday, April 12, 2011 1:09:39 PM

Item ID: D4323-23
Revision ID: PRELIM
Item Name: Access Panel
Start Date: 4/12/2011 **Start Qty:** 2.00
Required Date: 4/15/2011 **Req'd Qty:** 2.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo Eagle	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/04/14 (2)

11/5/16

POSITIVE RECALL
EFFECTIVE 11/4/13 AUTH LA
RELEASED NP DATE 11/05/12

RD2370 CL 11/04/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 1:09:33 PM

Work Order ID: 68377

Parent Item: D4323-23

Parent Item Name: Access Panel

Start Date: 4/12/2011 **Required Date:** 4/15/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: RIPP RevA New Issue 11-03-01 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	530.6026	3.46875	6.9375			

6185 KYDEX .080"

Location	Loc Qty	Loc Code
therm	530.602647	
116576	530.602647	

21/04/11

6.9375 sq ft

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68377
Description:	Part Number:	D4323-23
Inspection Dwg: D4323-23 Rev: PA9		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/4 "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DL	Date:	11/04/13

TRIMMING SECTION

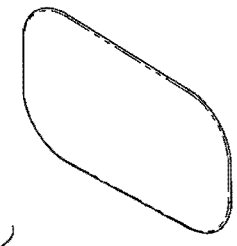
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
19.50"	+/- 0.030	19.3"	✓			~~see~~ attached
12.09"	+/- 0.030	12.0"	✓			
11.28"	+/- 0.030	11.25"	✓			
		See PA10		✓		

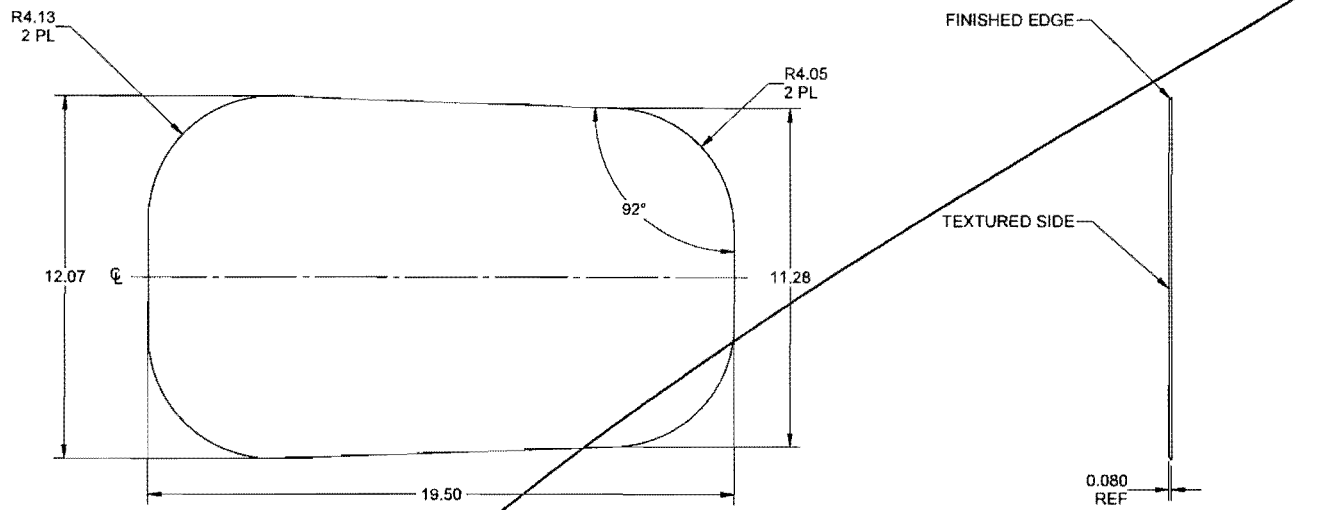
Measured by:	DL	Date:	11/04/13
Audited by:		Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

#68377





D4323-23 ACCESS PANEL

PAID

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 0.84 lb
8) TOOLING: THERMOFORM -23 PART PER MOLD DTXXXX.
TRIM PER MOLD LEAVING FINISHED EDGE
9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

DESIGN	BC	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	BC	
CHECKED		DRAWING NO. D4323 REV. PA9
MFG. APPR.		SHEET 14 OF 15
APPROVED		TITLE PANEL SCALE NTS
DE APPR.		
DATE	11.02.09	

COPYRIGHT © 2011 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	68377
Description:	Part Number:	D4323-23
Inspection Dwg: D4323 Rev: PA10		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

See Previous FAI

Measured by:		Date:	

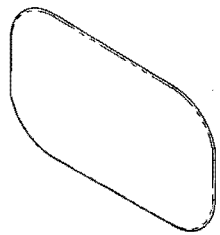
TRIMMING SECTION

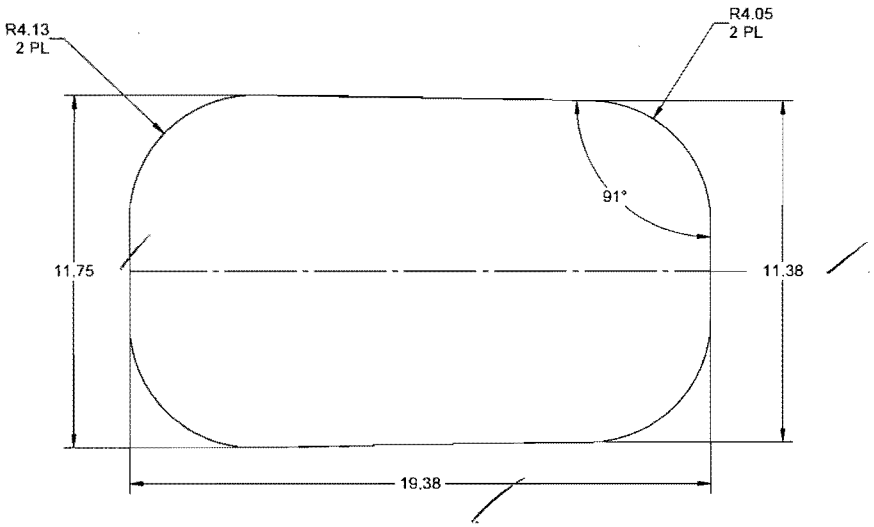
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.75	+/- 0.030	11.75	✓		Type A Plugs	
11.38	+/- 0.030	11.375	✓		" "	
19.38	+/- 0.030	19.375	✓		" "	

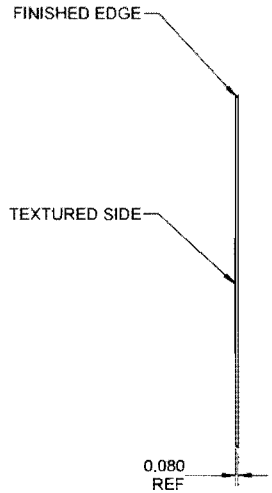
Measured by:		Date:	11.04.14
Audited by:		Date:	11/04/14
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14







D4323-23 ACCESS PANEL

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 0.82 lb
8) TOOLING: THERMOFORM -23 PART PER MOLD DTXXXX.
TRIM PER MOLD LEAVING FINISHED EDGE
9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

DESIGN	BC	**DART AEROSPACE LTD**
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4323 — REV. PA10
MFG. APPR.		SHEET 14 OF 15
APPROVED		TITLE: PANEL — SCALE: NTS
DE APPR.		
DATE	11.02.09	

COPYRIGHT © 2011 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

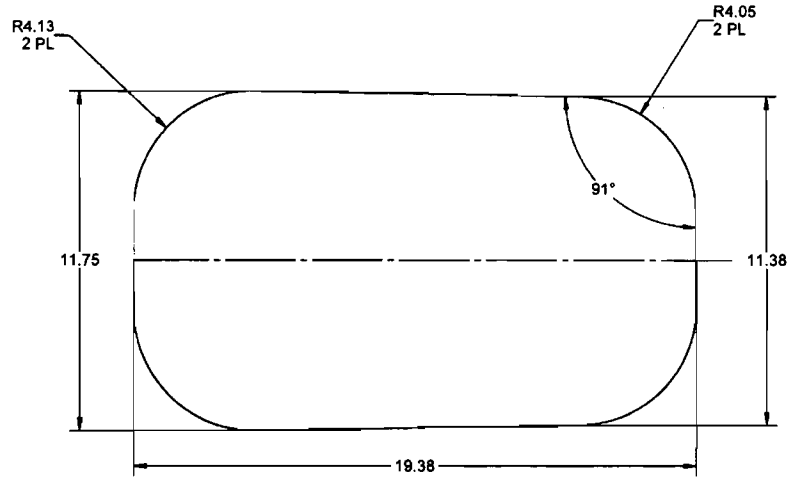
The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

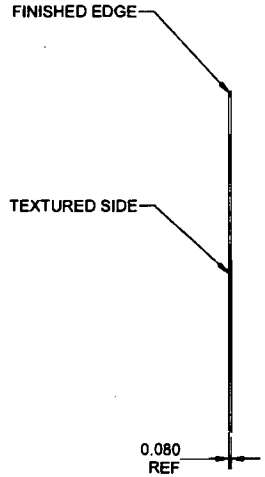
Thanks,

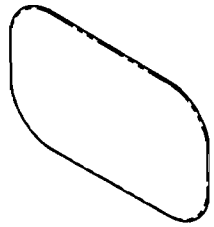
Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

The information contained in this transmission is privileged and confidential and intended only for the use of the individual or entity to whom it is addressed. If you are not the intended recipient, you are hereby notified that any distribution, copying, disclosure or taking of any action in reliance on the contents of this transmission is strictly prohibited and review by any individual other than the intended recipient shall not constitute waiver of privilege. If you have received this transmission in error, please notify me immediately and delete the original transmission.







68377

RELEASED
2011 -05- 10

D4323-23 ACCESS PANEL

NOTES:
1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
7) WEIGHT: 0.82 lb
8) TOOLING: THERMOFORM PER MOULD DT9733 AND DART QSI 022
9) TRIM PER MOLD LEAVING FINISHED EDGE
10) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	BC	
CHECKED	[illegible]	DRAWING NO. D4323 — REV. A
MFG. APPR.	[illegible]	SHEET 14 OF 15
APPROVED	[illegible]	TITLE: PANEL — SCALE: NTS
DE APPR.	[illegible]	
DATE	11.04.21	

COPYRIGHT © 2011 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.